

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006475**Date Inspected:** 30-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu zhi cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Side plate / Deck plate**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # CROSS BEAM 03

This QA inspector performed Ultrasonic Test of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Ultrasonic Test report for this date. The member is identified as Side plate / Deck plate. The weld designations reviewed are as follows:

(CD205D-001-006,010,002,001,009,005,008,004)

(CD205B-001-013,014)

(CD205F-001-004,008)

This QA Inspector randomly observed the following work in progress:

OBG # SEG 4BW

Flux Cored Arc Welding Process:

Welding of weld joint -025,026,027,028 located on PCMK BP019-001. Welder is identified as 220069. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2132.

Welding of weld joint –025,026,027,028 located on PCMK BP020-001. Welder is identified as 220069. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Welding of weld joint –025,026,027,028 located on PCMK BP021-001. Welder is identified as 220069. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Shield Metal Arc Welding Process:

Welding of weld joint –001 located on PCMK OBE4-001. Welder is identified as 048617. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F) Repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
